

Date: Friday, 9/14/2007 2:00:53 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GUSSET	
Job Number	34671C				
Estimate Number	10843				
P.O. Number	N/A		Part Number	D22495	
This Issue	9/14/2007	S.O. No.	N/A	Drawing Number	D2249 REV. E
Prsht Rev.	NC			Project Number	N/A
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	E
Previous Run	31609C			Material	N/A
Written By			Due Date	10/20/2007	Qty: 20 Um: Each
Checked & Approved By	<u>KJ/07.09.17</u>				
Comment	Est: D 05/02/04 Added Step 9 KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304S16GA	304/316 .063 Sheet		
		Comment: Qty.: 0.0243 sf(s)/Unit Total : 0.4860 sf(s) 304/316 .063 Sheet Material: AISI 304/316 SS 0.063" thick (M304S16GA) Batch: <u>M10S130</u>		<u>07/09/22</u>
2.0	SHEAR	SHEAR		
		Comment: SHEAR Cut blank: 1.000" x 1.600"	<u>SAD</u>	<u>07/09/22</u> 20
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr any rough edges	<u>SAD</u>	<u>07/09/22</u> 20
4.0	QC5	INSPECT WORK TO CURRENT STEP		 <i>coasters</i>
		Comment: INSPECT WORK TO CURRENT STEP	<i>En</i>	<u>07/09/22</u> 20
5.0	PACKAGING 1	PACKAGING RESOURCE #1		
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>Ep</i>	<u>07/09/24</u> 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 21 Date: 01/09/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:53 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 34671C

Part Number: D22495

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

2007/09/24

Job Completion



W 09-24

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

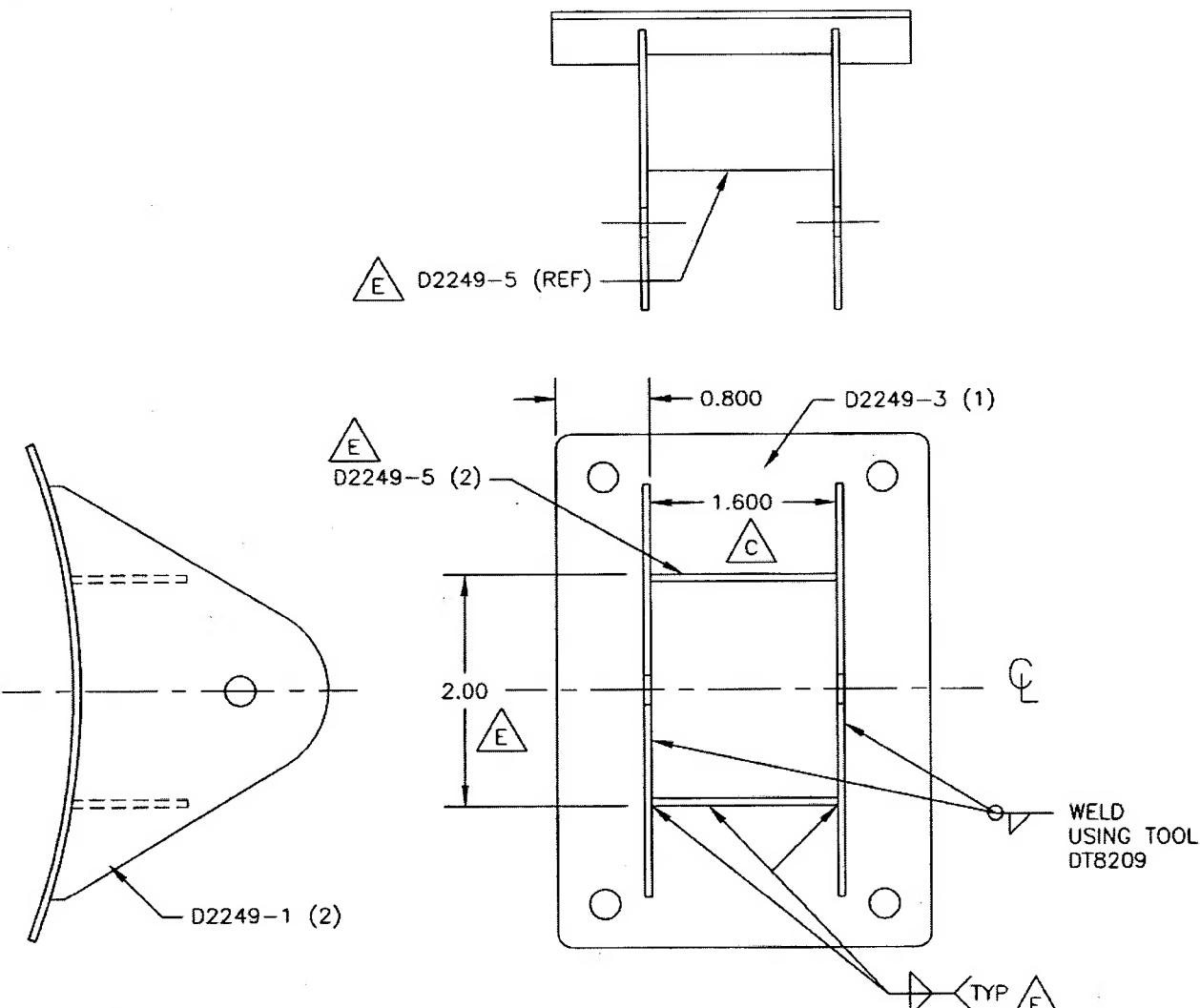
**RELEASED**

99.10.12 KC

**DART**

© DART  
1994

DESIGN KC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KC	APPROVED H	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	\$0.261 WAS \$0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



MATERIAL: AISI 304/316 SS, 0.063 THICK

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

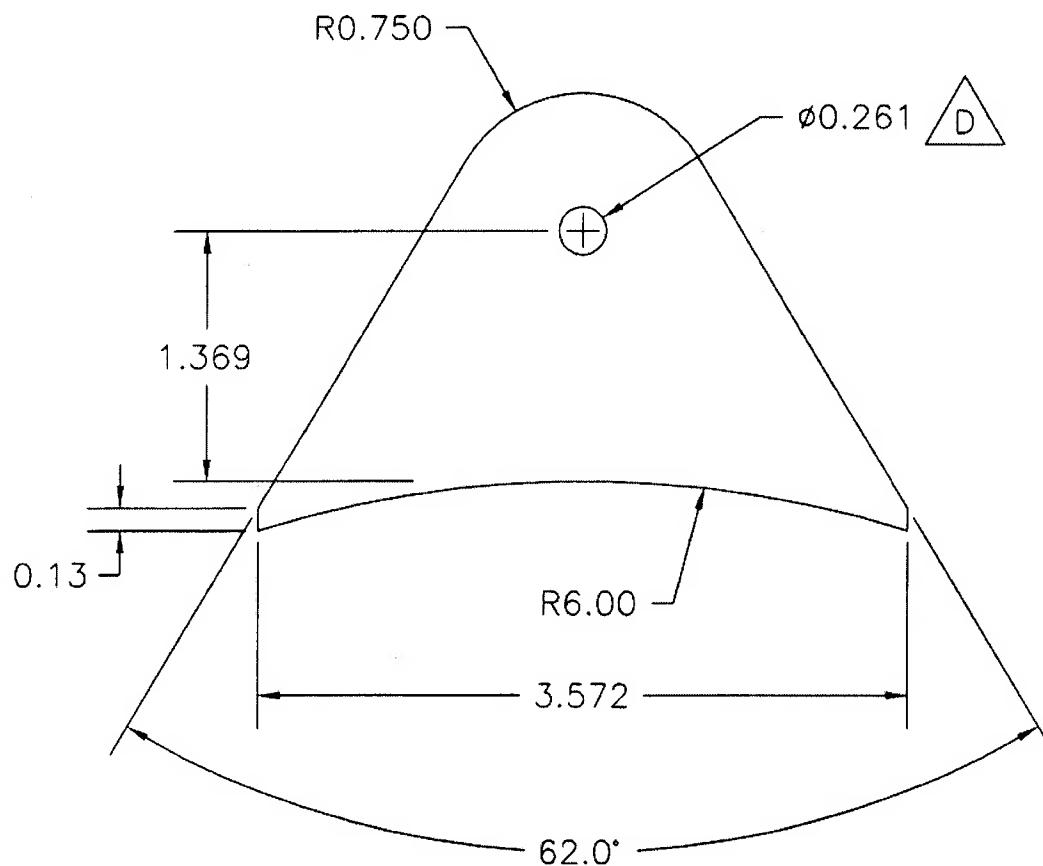
ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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WITHOUT NOTICE  
WORK ORDER  
NO. 2471C

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

**RELEASED**  
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

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WITHOUT NOTICE  
WORK ORDER  
NO. *34671C*

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>M</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

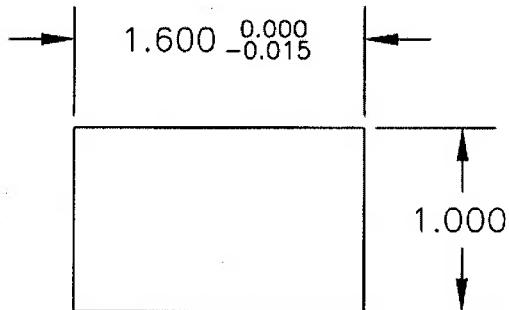
**RELEASED**  
99.10.12 KE

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SP</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

**RELEASED**

99.10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO *34607LC*